

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008588**Date Inspected:** 30-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

CWI Name:	Pin-Tang Hsu		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	Tower, Jacking and Deviation Saddles		

Bridge No: 34-0006**Summary of Items Observed:**

On this date, 7/30/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W2 - Plate rib edges 5-4 and 5-6 were being carbon arced, due to an excess material condition of ribs, by JSW personnel. Saddle structure is located in Fabrication Shop #4.

W2W3 - Saddle section is being ground to provide proper transition and profile of completed welds, before repositioning, in Fabrication Shop #4.

TOWER SADDLES

T1-3 - Stiffener plates 9ST-28, -29, -30 were in process of being fit up by JSW personnel, due to angular differences and to assist in fit up the 50mm plate, corners were chamfered, creating root openings requiring fillet leg size be increased per that established by AWS D1.5 Bridge Welding Code, ¶ 3.3.1 (for fillet welds). CWI, Mr Chung Fu Kuan was briefed on requirements to adjust fillet size and track joints to assure adjusted minimum fillet sizes are met. See attached photos for those chamfers needing the most adjustment (of the three plates identified in the opening statement). Also observed was, plate 9-9 edge, noted in WIR-007639, was getting weld build up by surfacing per BG-ECS-08-041 and associated WPS SJ-3012-6 Rev 5. Welder was K.Kobayashi 08-5023, using

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SMAW process, in a 2F position, depositing E7016 4mm electrode. This observation took place while QA CWI Mr. Chung Fu Kuan reviewed welders parameters randomly in the Fabrication Shop #4. Upon CWI shift change, Mr. Pin-Tang Hsu assumed the duties of verifying Mr Kobayashi's parameters.

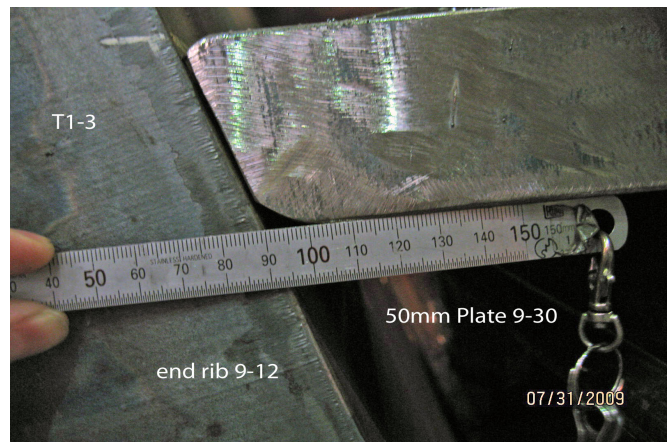
EAST SADDLES

E2E1 - Cast section now awaiting grinding of excess reinforcement per JSW representative Mr. Hideaki Kon, in the weld pit in Foundry.

E2W1 - Casted section is idle awaiting repositioning to continue UT and MT of repair welds. Located in Foundry Shop.

West Jacking Saddle - Foundry NDE technician H.Kohama #86 was in process of performing UT of as shaped/dressed surface of casting, currently scanning ribs with longitudinal dual element transducer and an A scan Panametrics scope. This cast section is located in the Foundry.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.



Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Brcic,Michael

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer